

Work Order ID 129686

February-23-15 10:16:10 AM

129686

Page 1

Item ID: D206-802-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crew Door Opener LH 206A/B

Start Date: 2/16/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1502-24 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D407-802-2	A	J.A

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D206-802-021 CHG002

DAS
6
9-89

AUG 19 2015

105 Pick Kit 0.00

105

Packaging

Packaging

Memo

0.00

① J.A

AUG 17 2015

DAS
26
9-89

110 QC4- 100% Inspect kits for completeness 0.00

110

QC

Quality Control

Memo

0.00

DAS
6
9-89

AUG 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129686

February-23-15 10:16:10 AM

129686

Page 2

Item ID: D206-802-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crew Door Opener LH 206A/B

Start Date: 2/16/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120						DAS 6			
Packaging	Memo	0.00				9-89			
Packaging	Identify and pack for shipping as per PPPDD206-802-021 Location: <u>021</u> PPP rev: _____							AUG 19 2015	
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control						MLJ		AUG 19 2015	

Sht 20150819

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:16:09 AM

Page 1

Work Order ID: 129686

129686

Parent Item: D206-802-021

D206-802-021

Parent Item Name: Crew Door Opener LH 206A/B

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-15

Manufactured

No

105

Each

6.0000

1 1

D3552-15

Door Prop

DAS
6
9-89

Location

Loc Qty

Loc Code

ST363

6

121617

4

88100

2

D3622-5

Manufactured

No

105

Each

24.0000

2 2

D3622-5

Ball Stud

DAS
6
9-89

Location

Loc Qty

Loc Code

ST052

24

104978

24

D4110-1

Manufactured

No

105

Each

8.0000

1 1

D4110-1

Door Doubler, LH

DAS
6
9-89

Location

Loc Qty

Loc Code

ST091

8

86147

8

D4110-3

Manufactured

No

105

Each

2.0000

1 1

D4110-3

Doubler, Sill

DAS
6
9-89

Location

Loc Qty

Loc Code

ST091

2

121635

2

8125995

**

JA

AUG 17 2015

DAS
26
9-89

DAS
26
9-89

DAS
26
9-89

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

February-23-15 10:16:10 AM

Page 2

Work Order ID: 129686

Parent Item: D206-802-021

Parent Item Name: Crew Door Opener LH 206A/B

129686

D206-802-021

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

CR3242-4-2

Purchased

No

105

Each

230.0000

5

5

CR3242-4-2

RIVET

**

JA

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST317

230

m128813

30

m131340

200

MS20426AD4-5

Purchased

No

105

Each

2,515.000

4

4

MS20426AD4-5

RIVET

**

JA

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

2441

m125807

60

m130922

2381

ST312

74

m125807

74

MS20600-AD4W2

Purchased

No

105

Each

1,001.000

13

13

MS20600-AD4W2

Rivet

**

JA

AUG 17 2015

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK004

800

m126475

800

GA

154

m125708

154

ST309

47

m126475

47

13

February-23-15 10:16:10 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:16:10 AM

Page 3

Work Order ID: 129686

Parent Item: D206-802-021

Parent Item Name: Crew Door Opener LH 206A/B

129686

D206-802-021

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

52.0000

2 2

MS21073L5

Anchor Nut

**

JA

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST300

52

m130799

6

m131187

46

NAS1149C0532R

Purchased

No

105

Each

477.0000

2 6

NAS1149C0532R

WASHER

**

JA

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

415

m128537

215

m131624

200

NAS1149C0563R

Purchased

No

105

Each

346.0000

6 6

NAS1149C0563R

Washer

**

JA

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST271

346

m125928

5

m131026

341

MS27130-A26

Purchased

No

105

Each

55.0000

6 1

MS27130-A26

Rivnut

**

JA

AUG 17 2015

DAS
26
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST279

55

16521

55

February-23-15 10:16:10 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Ref

DAS
6
9-89

DART AEROSPACE LTD.

IIN-D206-802-2
Page 23 of 25

5.0 PARTS LIST

5.1 D206-802-021/-022 Crew Door Opener Kits

Qty -021-	Qty -022	Part Number	Description
1		D206-802-021	CREW DOOR OPENER KIT, LH
		D206-802-022	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4110-1	DOOR DOUBLER
	1	D4110-2	DOOR DOUBLER
1	1	D4110-3	DOUBLER, SILL
5	5	CR3242-4-2	RIVET
4	4	MS20426AD4-5	RIVET
13	13	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT (OR A10-130)
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-023/-025 High Vis Crew Door Opener Kits

Qty -023	Qty -025	Part Number	Description
1		D206-802-023	HIGH VIS CREW DOOR OPENER KIT, LH OR RH
		D206-802-025	HIGH VIS CREW DOOR OPENER RETROFIT KIT
1	1	D3552-17	DOOR PROP
2	2	D3622-7	BALL STUD
1		D4110-3	DOUBLER, SILL
1	1	D4111-3	SILL FITTING
2	2	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
13		MS20600AD4W2	RIVET
1		MS21073L5	ANCHOR NUT
1	1	MS27039C5-11	SCREW
1		MS27130-A26	RIVNUT (OR A10-130)
2	2	NAS1149C0563R	WASHER

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Revision: A
Date: 10.10.13